



REPLACEMENT PARAGRAPH - PAGE 3, LAST PARAGRAPH
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Roofing sheet having standing seam, where the raised longitudinal edges of the sheet-metal plates are terminated by beads that are snapped together, are normally only used as straight sheet-metal plates. SE 0103229-1 and PCT/SE02/01689 (corresponding to U.S. Serial No. 10/806,865 filed March 23, 2004 and published as US 2004-0173002A1 on September 9, 2004) provide, however, a method and a machine for bending such sheet-metal plates. The raised edges are rolled thinner against the beads in order to get a bending that is adapted for a convex roof, for instance a domed roof, or the raised edges are instead rolled thinner against the bottom when a bending adapted for a concave roof is desired. In this application for roofing sheet, the actual bending adapted for a concave roof is desired, in this application for roof sheet, the actual bending radius may vary fairly much from the one desired by virtue of stresses in the roll-shaped sheet metal. Therefore, the present invention has a particular bearing on that product. The invention is directly applicable on the machine that is shown in these patent applications, but it is also possible to supplement the machine shown in the references with the bending rolls 15 and 16 shown in the present application. These rolls are then arranged after the rolling rolls and provide a last bending for final adjustment of the bending radius. It is possible to control both the rolling rolls and the roll 15 in response to the calculated actual bending radius or only control

the roll 15 in this way. The bending device will in this case comprise both the rolling rolls according to the above-cited publications and the bending rolls 15 and 16. The machine according to the above-mentioned publications is ~~illustrated in Figure 2 of the drawing described herein is not described but reference is made to the aforementioned published U.S. patent application.~~